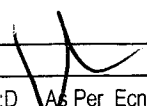
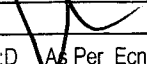


Date: Wednesday, 15/08/2007 3:50:24 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 STEP ASSEMBLY
Job Number	: 33924		
Estimate Number	: 11798		
P.C. Number	: N/A	Part Number	: D206628034
This Issue	: 15/08/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 31239	Material	: N/A
		Due Date	: 10/09/2007
Written By	: 	Qty:	3 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-034 CHG 002

2
 KJ 07/09/06 (3)

2.0	33924A	FLOAT STEP ASSEMBLY RH (206/407)
-----	--------	----------------------------------



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2842-042 B 33924A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27313	Mounting Lug
-----	--------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-3 Mounting Lug

1530994, 50

5.0	D28441	Arm
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

153400

7/9/04 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 33924

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2844-1

Arm

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

34001

SP

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2605 f(s)/Unit Total: 3.7816 f(s)

Pick:

Qty Part #

Description

Batch

2 D2856-400 6.25"

Abrasion Strip

25656

SP

8.0

D3394041

LUG ASSY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-041

LUG ASSY

130997

SP

9.0

AN4C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C12A

Bolt

1104937

SP

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

1105143

7/9/14 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 33924

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915

SP

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 9.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

3 AN960C10

WASHER

M101064

SP

13.0

AN960JD416L

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L

Washer

M105408

SP

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L

Washer

M105408

SP

(P10) →

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 MS21043-4

Nut (or MS21042-4)

M105115

SP

(P10) →

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 NAS1515H3

Washer

M105164

7/9/14 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/17	# 15.0	R.C. Human error wrong Batch numbers found on all these kits. Numbers do not match the kit to the w/o.	<u>PS/042</u>	Remove incorrect Batch numbers	<u>SP</u>	<u>EP</u> 07/09/17	<u>PS/042</u>	<u>EP</u> 07/09/17
07/09/17	# 14.0	one kit missing <u>D</u> M51515 H4th washer R.C. human error	<u>PS/042</u>	add washer to kit	<u>SP</u>	<u>EP</u> 07/09/17	<u>PS/042</u>	<u>EP</u> 07/09/17

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 33924

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

In box
0209.17 (3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-034

Location: _____

PPP Rev: _____

0209/17 (3)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(3)

0209/19

Job Completion



U 0209.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

628, 034

Dart Aerospace Ltd.

Date: Wednesday, 15/08/2007 3:50:36 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY RH (206/407)
 Job Number : 33924A
 Estimate Number : 11775
 P.C. Number : *N/A* Part Number : D2842042
 This Issue : 15/08/2007 S.O. No. : *N/A* Drawing Number : D2842 REV B
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 33922A Material : *N/A*
 Written By : *[Signature]* Due Date : 10/09/2007 Qty: 3 Um: Each
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B32858</i>

Check Material for any Dents or Defects

am 07.08.24 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8272 as per Dwg D2842

3-Deburr and bevel ends for welding

am 07.08.24 3

PE 07.09.05 3

PE 07.09.05 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>333861 = 1</i> <i>330883 = 2</i>

PE 07.09.05 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33924A

Part Number: D2842042

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	D34591	plate
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

plate

Batch: 333207

SE 07.09.05 3

5.0	D34593	plate
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

plate

Batch: 333226 = 4
= 2

SE 07.09.05 3

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs as per Dwg.D2842

A/R AL Rod Batch: M103794
M104721

2-Grind end cap weld flush

Q.M

07.09.06

3

SE 07.09.06 3

7.0	DO NOT USE <i>QC#579</i>	WELD INSPECTION
-----	-------------------------------------	-----------------



Comment: WELD INSPECTION

QC9 M07/09/06 (3)
QC5 07.09.06 (34)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.09.06

3

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	-----------------------------------------



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 07.09.10 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33924A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M103794

Handwritten: 07-09-10 3

2-Grind end cap weld flush.

Handwritten: a.m 07.09.10 3

11.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 07/09/11 (3)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 07-09-11 (3RH)

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Handwritten: M105068

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M-1 07-09-11 (3)

14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: ml 07 09 11

Handwritten: (3)

15.0 NAS1329C3KB130 insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

3 NAS1329C3KB130Insert M105385

Handwritten: ml 07 09 11

16.0 MS27039C107 screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 MS27039C1-07 Screw

Handwritten: ~~M105385~~ M105426

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 3:50:36 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY RH (206/407)

Job Number: 33924A

Part Number: D2842042

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 NAS1515H3L WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 NAS1515H3L

WASHER

M104603

ml 07 09 11

18.0 AN960C10L washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number

Description Batch

3 AN960C10L

WASHER

M105143

ml 07 09 11

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: FINISHING 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.

Batch: M105386

ml 07 09 11 (3)

ml 07 09 11

(3)

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

100% (3)

21.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP . 33924 6 7/9/17 (3)

22.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

100% (3)

Job Completion



u 07.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

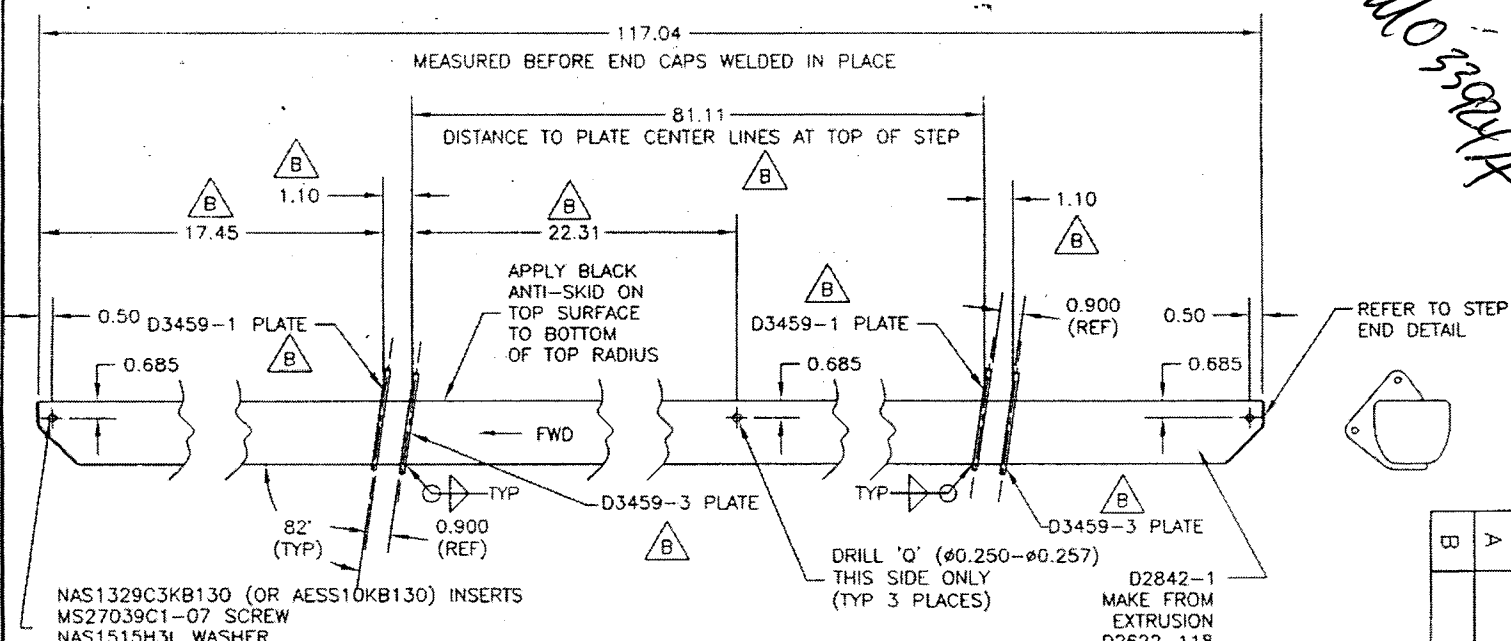
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

11033001X



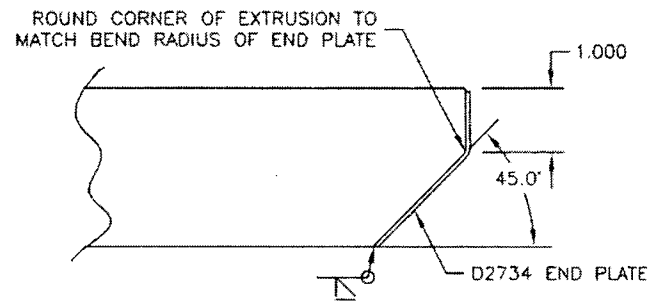
NAS1329C3KB130 (OR AESS10KB130) INSERTS
 MS27039C1-07 SCREW
 NAS1515H3L WASHER
 AN960C10L WASHER
 (TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004 -

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
 NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		PORT HADLOCK, WA	
DATE	05.09.23			DRAWING NO.	D2842
				TITLE	206L/407 FLOAT STEP ASSEMBLY
				SCALE	NEW ISSUE
				REV. B	SHEET 1 OF 1
					RE-DESIGN, ADD D3459-1/-3

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

RELEASED
 05.11.14

*Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-628-034

Job Number : 37233

Estimate Number : 10804

P.O. Number :

This Issue : 05/02/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : LARGE FAB ASSY

Previous Run : 37232

Part Number : D206628034

Drawing Number : ECN 1118

Project Number :

Drawing Revision :

Material :

Due Date : 12/02/2008

Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment :

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

1- 30807

003

D206-628-034 CHG002 1x B33924 ✓

33924

①

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118

*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER ***

8x D2732 RUBBER EXTRUSION

CUT 3.00" LONG B

34717

B34717 D8 (U)

8x AN4C14A BOLT B

107082

M107082 (X1)

8/2/12

50

(X)

3.0

D2732

Rubber Extrusion



Comment: Qty.: 82.0000 f(s)/Unit Total : 82.0000 f(s)

Rubber Extrusion

134717

4.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

M107082

8/2/12

50

(X)